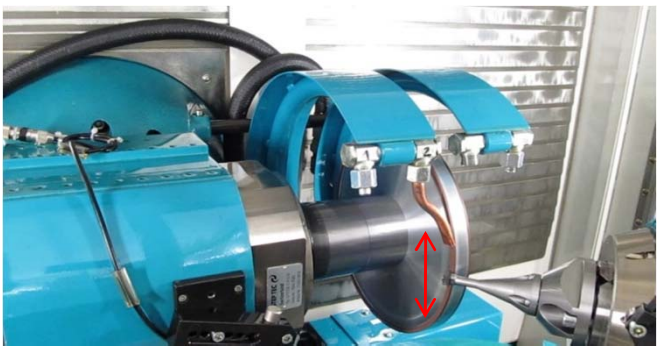
**Application Data Sheet**

SCHNEEBERGER

# Milling Insert 2Radii 16 x 6.35

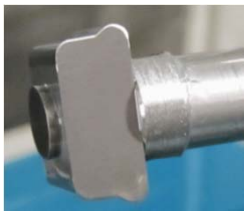
A08-150



In order to get a completely straight surface along this double radius insert, an oscillation movement is superimposed on the movement along the profile. The required k-land is executed with a sharp metalbonded wheel. Continuity in large production batches with automatic loading is garanteed with TTC clamping, probing and dressing. For saving grinding time and if the requirements on the straightness of the surface are less important, oscillating can be omitted.

## 1. Cycletime for Production

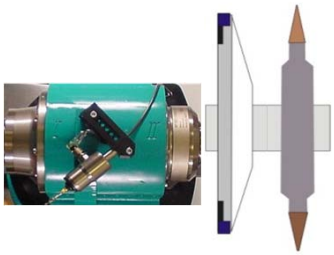
| Workpiece: Doublesided Insert 16x8x6.35 mm Material CARBIDE | | | | | |
|---|---|---|---|---|---|
| Operations | Probe | Prf oscill. | Prf kland | Dress | Load |
| Feed [mm/Min] | 2000 | 3000 | 30 | 500 | 9000 |
| Power [kW] | | 1 | 1 | 2 | 1 |
| Cutting speed [m/s] | | 22 | 22 | 50 | |
| Used wheels | | 1 | 2 | 1 | |
| Grinding time [s] | 12 | 269 | 118 | 22 | 16 |
| Total cycle time | 7 Min 17 | | | | |



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

## 2. Used Grinding Wheels

| | |
|---|---|
| 1 | 12C9 Ø250 D91 |
| 2 | 14EE1 Ø200 D46V20° |



1 2

## 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM
Control: Fanuc 31i
Accessories: TTC clamping, Dressing, STL6056
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

Responsible engineer: OP, 20.1.2014

www.schneeberger.ch
J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, China

TECHNOLOGY FOR TOOLING